

Date: Thursday, 3/13/2008 10:19:08 AM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 37922	
Estimate Number : 10531	
P.O. Number :	Part Number : D2572
This Issue : 3/13/2008 S.O. No. :	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 37565	Material :
Written By :	Due Date : 4/4/2008 Qty: 10 Um: Each
Checked & Approved By : <u>08 03 13</u>	
Comment : Est. 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ	

## **Additional Product**

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: B34874

ml 08/03/02

10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. 37922 Double check by: DJP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

ml / J.L 08/04/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

ml / J.L 08/04/02

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/13/2008 10:19:08 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 37922

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S.F. 08/04/02

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. H.

08/04/02

10X

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 107550

16K

08-04-03

10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SL

AS.

08-04-03

10

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS 08/04/04

10

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



U 08.04.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37922</b>
<b>Description: Saddle, Fwd Inboard</b>	<b>Part Number:</b>	<b>D2572</b>
<b>Inspection Dwg: D2572 Rev. E</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.502	.502	.507	.502		
G	0.257	0.262		.266	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.499	.495	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.569	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.496	1.495		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.873	3.872	3.873		
P	0.115	0.135		.126	.129	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.254	.252	.251		
S	0.115	0.135		.130	.132	.133	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.966	2.960	2.960		
V	0.230	0.250		.287	.235	.236	.235		
W	0.115	0.135		.125	.135	.127	.129		
X	0.307	0.312		.309	.309	.308	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.258	.369	.355	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.623	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.243	.246	.246		
AE	1.375	1.395		1.387	1.392	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.255	.255	.259		
AH	0.240	0.260		.247	.245	.247	.245		
AI	2.000	2.020		2.001	2.005	2.000	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>MR / J.L</i>
Date:	<i>08/04/02</i>

Audited by:	<i>S.S</i>
Date:	<i>08/04/02</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	3722
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A5	A6	A7	A8	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.503	.502	.504	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.502	.501	.502		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.576	.572	.569	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.126	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.250	.250	.250		
S	0.115	0.135		.136	.129	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.958	2.958	2.958		
V	0.230	0.250		.235	.237	.237	.236		
W	0.115	0.135		.127	.127	.124	.123		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.360	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.623	.621	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.248	.246	.244		
AE	1.375	1.395		1.387	1.391	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.245	.248	.246		
AI	2.000	2.020		2.000	2.004	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	ML / J.L.
Date:	08/04/01

Audited by:	RF
Date:	08/04/01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37922
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X <sub>9</sub>	X <sub>10</sub>	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.001				
F	0.490	0.510		.502	.501				
G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.502	.502				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.564	.570				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.124	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.249				
S	0.115	0.135		.126	.124				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.958				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.126	.125				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.622	.623				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.244	.242				
AE	1.375	1.395		1.389	1.389				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.246	.247				
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

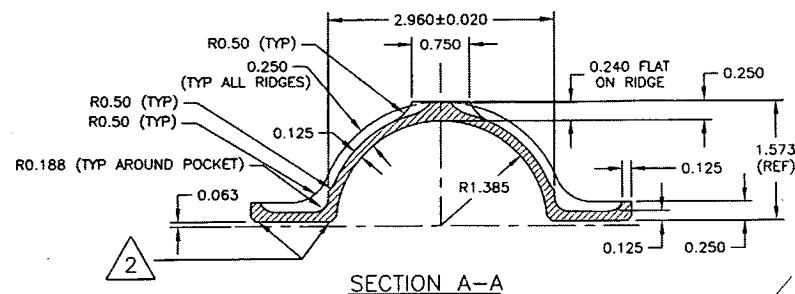
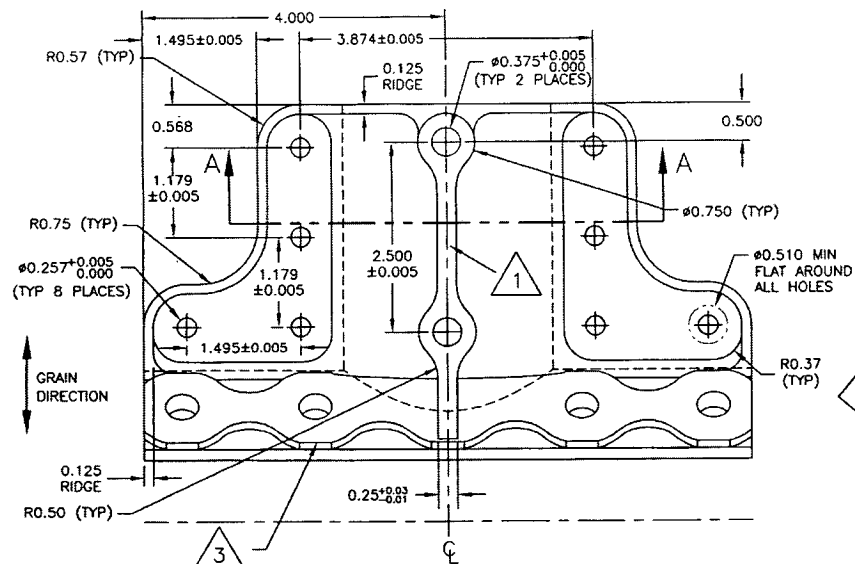
Measured by:	S.L.
Date:	08/04/02

Audited by:	S.F.
Date:	08/04/02

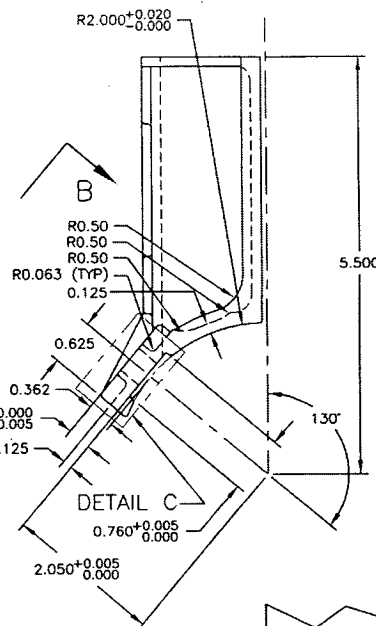
Rev	Date	Change	Revised by	Approved
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E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A



DETAIL C

0.438±0.005  
(TYP 4 PLACES)

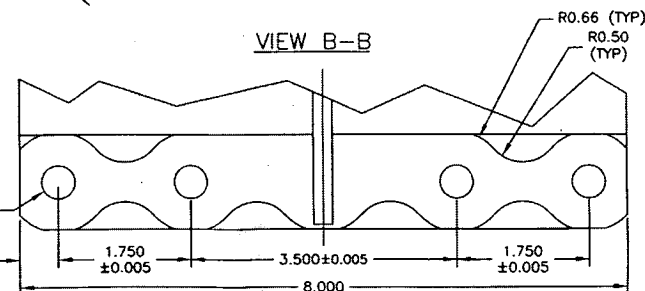
0.060  
0.025 (TYP)  
4 (TYP)

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  
2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)  
3 CHAMFER 0.063 x 45° ALL AROUND  
4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED		APPROVED
DATE	05.07.13	TITLE
		INNER FWD SADDLE

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

REV. E  
DRAWING NO. D2572  
SHEET 1 OF 1  
SCALE 2:3

DETAIL C  
SCALE 2:1

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 37922